

Work Order ID 63644

Monday, November 08, 2010 11:33:03 AM

Page 1

Item ID: D2221

Accept

Setup Start

Revision ID:

Stop

Item Name: 350 Basket Base

Start Date: 11/8/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 11/16/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10/1/08

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2221

Rev H

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
3- tack weld mesh on basket as per dwg D2221
A/R ER316 S.S. Rod Batch: 111585

10-11-23

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

10-11-24 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

5/10/11/24

Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1 BR 10-11-05

W/O:		WORK ORDER CHANGES					
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Setup Start



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
	Powdercoat								
Powder Coating	<div><div>Memo</div><div>1- Plug holes prior to 1st COAT: <i>11/15/2011</i> START TIME: <i>11:20</i> OVEN TEMPERATURE: <i>1100°</i> FINISH TIME: <i>11:50</i> *****2nd coat if necessary***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____</div></div>	0.00							<i>1 BR 10-11-25</i>
140	QC3- Inspect Part Finish	0.00							
	QC								
Quality Control	<div><div>Memo</div></div>	0.00							<i>EP 10/11/26 @</i>

1 *BL* 10-11-25

E/S 10/11/26 @

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: *6-A*

0.00

Packaging

Memo

*w/o
63643*

0.00

Packaging

EP 11/26 @

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/11/26 DJ
MF
10-11-26

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Monday, November 08, 2010 11:33:07 AM

[illegible]

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 		Manufactured	No			100	Each	6.0000	1	1			
Rib													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				6					
					61424			1					
					62519			5					
D2221-5 		Manufactured	No			100	Each	10.0000	2	2			
Rib													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				10					
					61753			2					
					62996			8					
D2221-7 		Manufactured	No			100	Each	5.0000	1	1			
Rib													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				5					
					61754			1					
					62997			4					

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Picklist Print

Monday, November 08, 2010 11:33:07 AM

Work Order ID: 63644

Parent Item: D2221

Parent Item Name: 310 Basket Base



Start Date: 11/8/2010

Required Date: 11/16/2010

Start Qty: 1.00

Required Qty: 1.00

D2232-3
Basket Hinge

Manufactured No

100 Each

4.0000



2

2

Pl 10.11.23

Location

Loc Qty

Loc Code

WA

4

63003

4

D2235-1
Basket Rib

Manufactured No

100 Each

10.0000



2

2

Pl 10.11.23

Location

Loc Qty

Loc Code

WA

10

62254

4

62988

6

D2581
Mounting Bracket

Manufactured No

100 Each

23.0000



2

2

Pl 10.11.23

Location

Loc Qty

Loc Code

WA

23

60470

3

61953

20

D3442-1
Shim

Manufactured No

100 Each

18.0000



2

2

Pl 10.11.23

Location

Loc Qty

Loc Code

WA

18

61181

6

63002

12

Pl 10.11.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Monday, November 08, 2010 11:33:07 AM

Page 3

Work Order ID: 63644

Parent Item: D2221











Parent Item Name: 300 Basket Base

Start Date: 11/8/2010

Required Date: 11/16/2010

Start Qty: 1.00

Required Qty: 1.00

D3825-041	Manufactured	No	100	Each	4.0000	2		<u>2</u> CPL 10.11.23
								
Rib Assembly (Basket End)								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	4				
			62994	4				
D3826-041	Manufactured	No	100	Each	4.0000	2		<u>2</u> CPL 10.11.23
								
Rib / Gusset Assembly								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	4				
			62986	4				
D3827-041	Manufactured	No	100	Each	5.0000	1		<u>1</u> CPL 10.11.23
								
Rib Assembly (Inboard)								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	5				
			62993	5				
D3832-1	Manufactured	No	100	Each	1.0000	1		<u>1</u> CPL 10.11.23
								
Mesh (Base)								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	1				
			62932	1				
D3833-1	Manufactured	No	100	Each	14.0000	2		<u>2</u> CPL 10.11.23
								
Mesh (Base End Face)								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	14				
			62383	4				
			63255	10				

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Shop Packet Print

Page 3

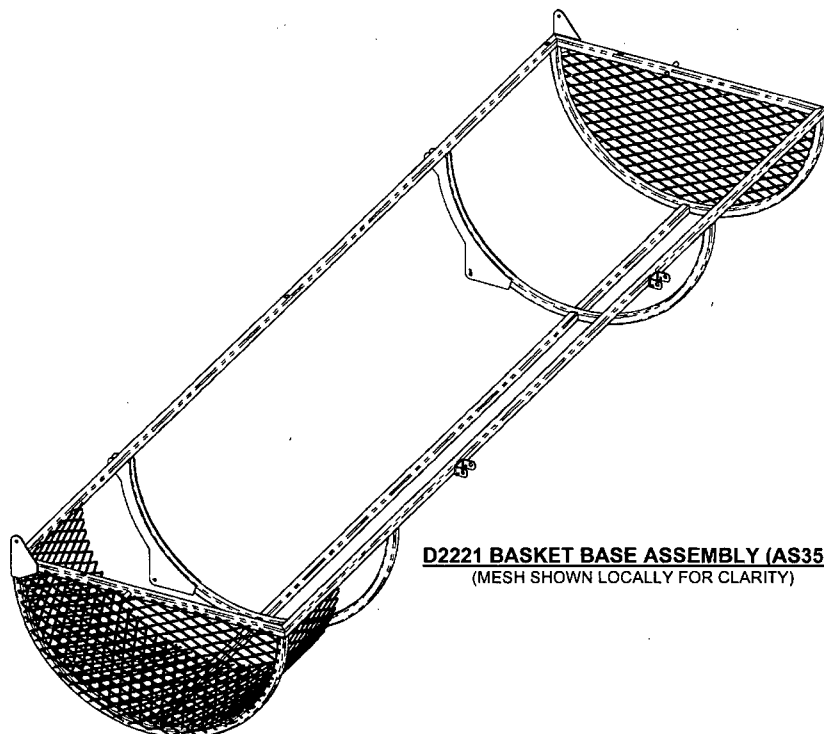
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D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 63644

BS 10-11-05

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN D8-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A8-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BS		
CHECKED	BS	DRAWING NO.	REV. H
MFG. APPR.	BS	D2221	SHEET 1 OF 5
APPROVED	BS	TITLE	SCALE
DE APPR.	BS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

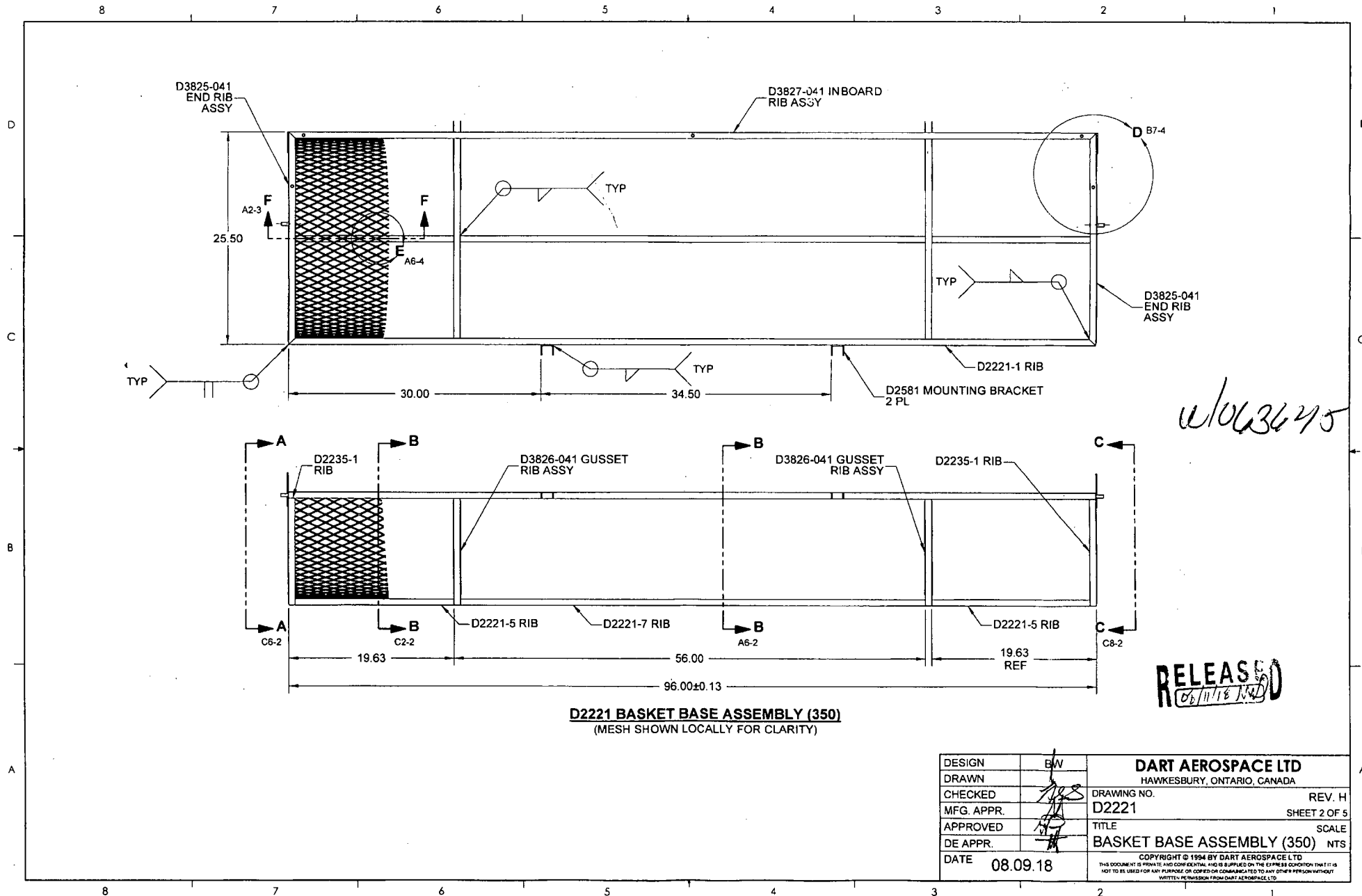
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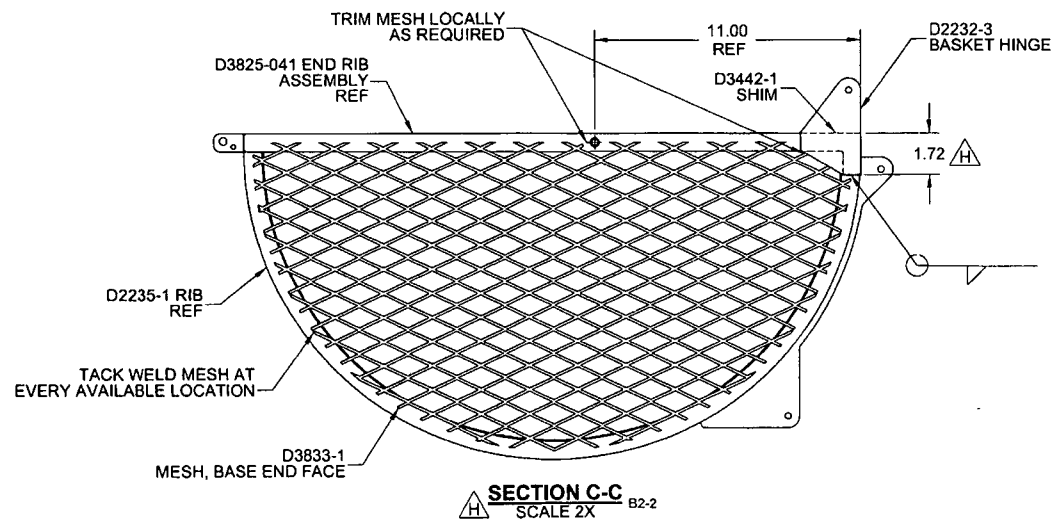
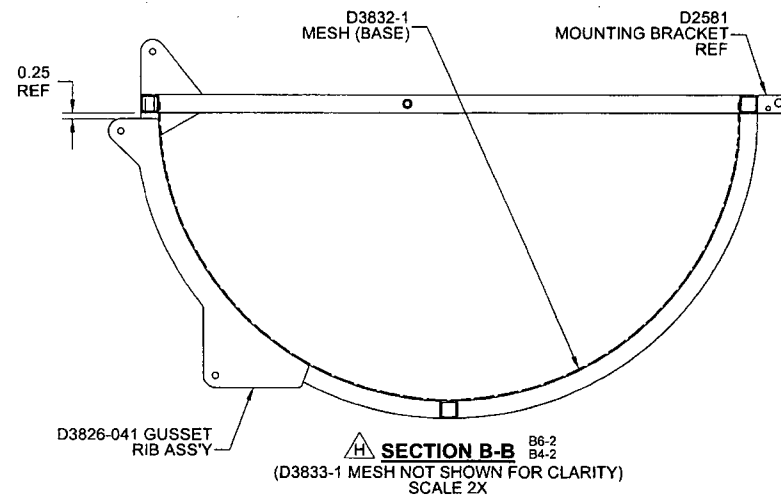
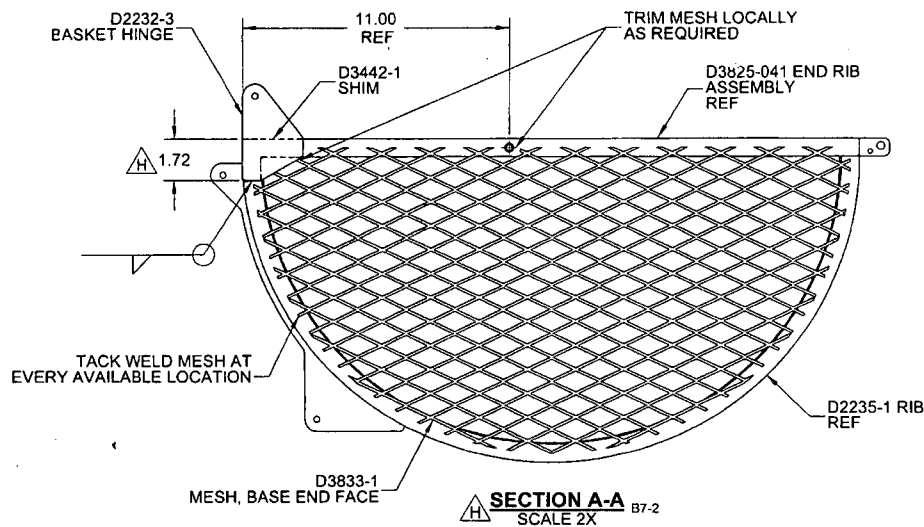
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u/b 63645

RELEASED
08/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO. D2221	REV. H
MFG. APPR.	JS		SHEET 3 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

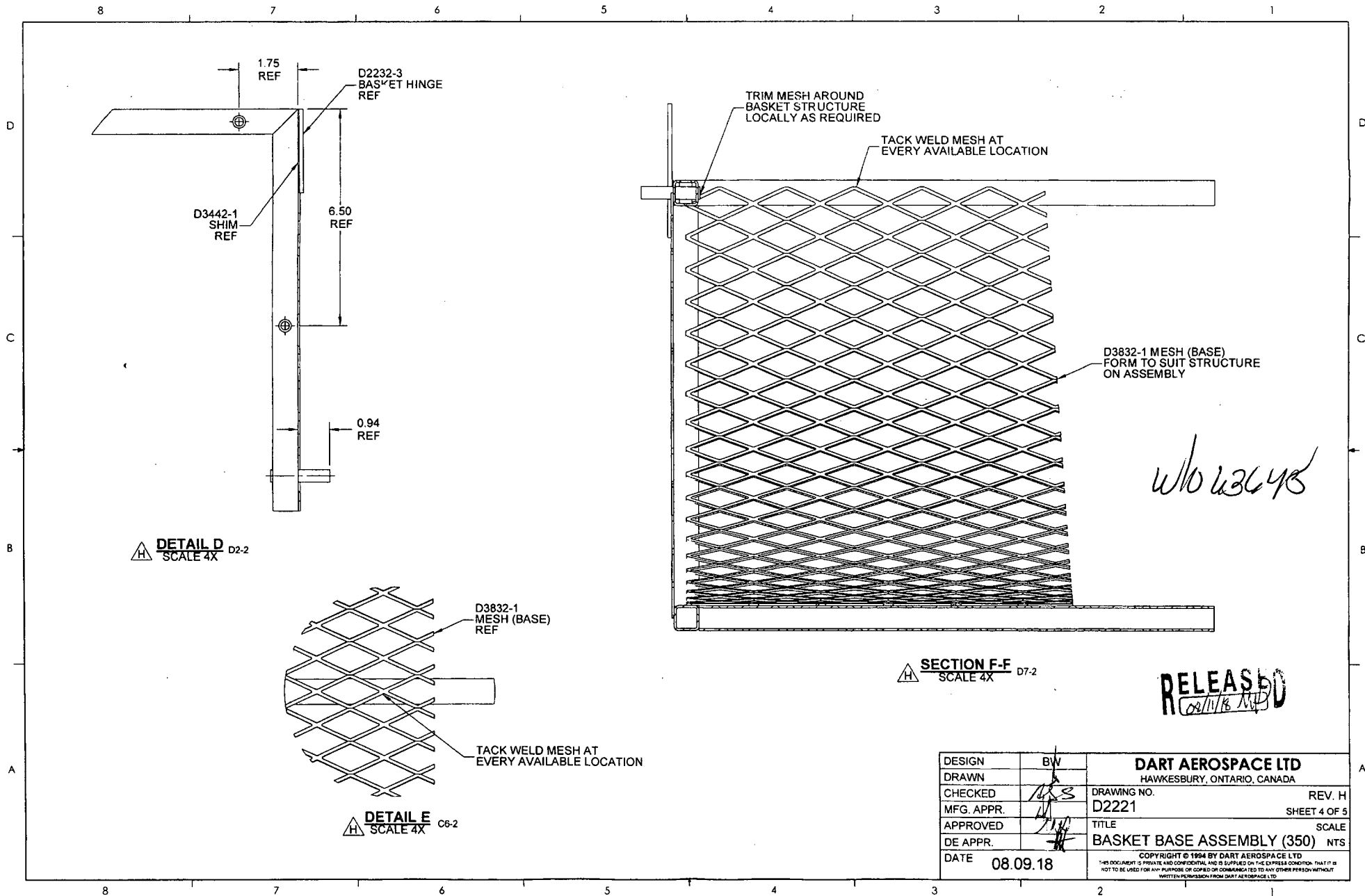
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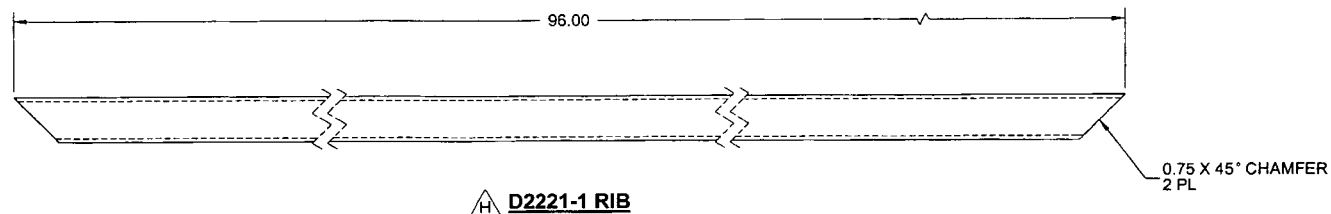
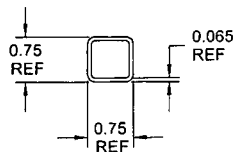
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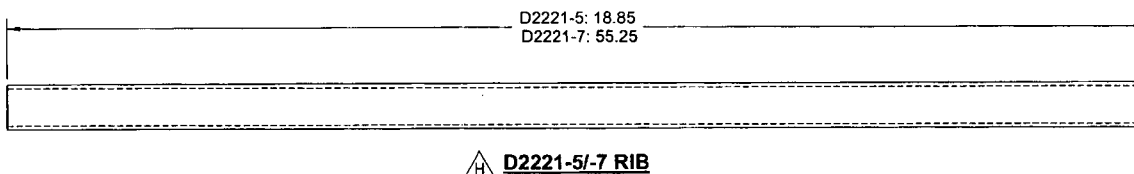
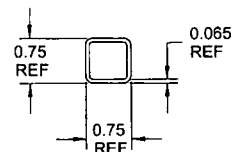
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also 03645



RELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMING TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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